

Date: Wednesday, 1/30/2008 7:57:15 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SLIDING PLATE  
 Job Number : 37084  
 Estimate Number : 11215  
 P.O. Number :  
 This Issue : 1/30/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D33333  
 First Issue : 11 Type : MACHINED PARTS Drawing Number : D3333 REV B  
 Previous Run : 35443 Drawing Revision : B  
 Material :  
 Due Date : 2/18/2008 Qty: 12 not enough Material  
 Written By :  
 Checked & Approved By : *JP 08 01 30* Um: Each  
 Comment : Est. A 05.01.13 New issue KJ/JLM

## Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 M1010B4000X00500 AISI 1010-1025 Steel Bar



Comment: Qty.: 0.7984 f(s)/Unit Total : 15.9684 f(s)  
 AISI 1010-1025 Steel Bar  
 Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel  
 (M1010-B4.000x00.500)  
 Identify for D3333-3  
 Batch: *B 106996* *DJP 08/02/17*

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut blanks: 4.000" x 0.500" thick x 9.620" long

*DJP 08/02/17* *(12)*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA483 and Dwg D3333  
 Identify as D3333-3

*JL 08/02/19*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*JL 08/02/19*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*JP 08/02/20*  
*(12)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 08/03/06

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:57:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING PLATE

Job Number: 37084

Part Number: D33333

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

B 8-3-4

Deburr and Grind 45° chamfer on opposite side of pocket along edges as per Dwg D3333

SA 08/03/05

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/05 (12)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Ensure to mask threaded holes and sides

M-6

08/03/05

(12x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-05

(12)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

484

8/3/5

(12x)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/06

(12)

Job Completion



2008/3/05

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37084
<b>Description:</b> Sliding Plate		<b>Part Number:</b>	D3333-3
<b>Inspection Dwg:</b> D3333 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	+/-0.010	3.901	✓			
9.50	+/-0.030	9.501	✓			
0.650	+/-0.010	.651	✓			
2.310	+/-0.010	2.311	✓			
1.125	+/-0.010	1.125	✓			
1.950	+/-0.010	1.949	✓			
1.200	+/-0.010	1.200	✓			
1.300	+/-0.005	1.300	✓			
R0.125	+/-0.010	.125	✓			
0.500	+/-0.010	.493	✓			
0.440	+/-0.010	.442	✓			
1.675	+/-0.010	1.675	✓			
0.035 x 45°	+/-0.010 x 0.5°	.04 x 45°	✓			
0.485	+0.000/-0.010	.480	✓			
1.11	+/-0.030	1.112	✓			
3/8 - 24 UNF	N/A					
0.450	+/-0.010	.448	✓			

<b>Measured by:</b>	J.L.	<b>Audited by:</b>	S.F.	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	08/02/19	<b>Date:</b>	08/02/20	<b>Date:</b>	N/A

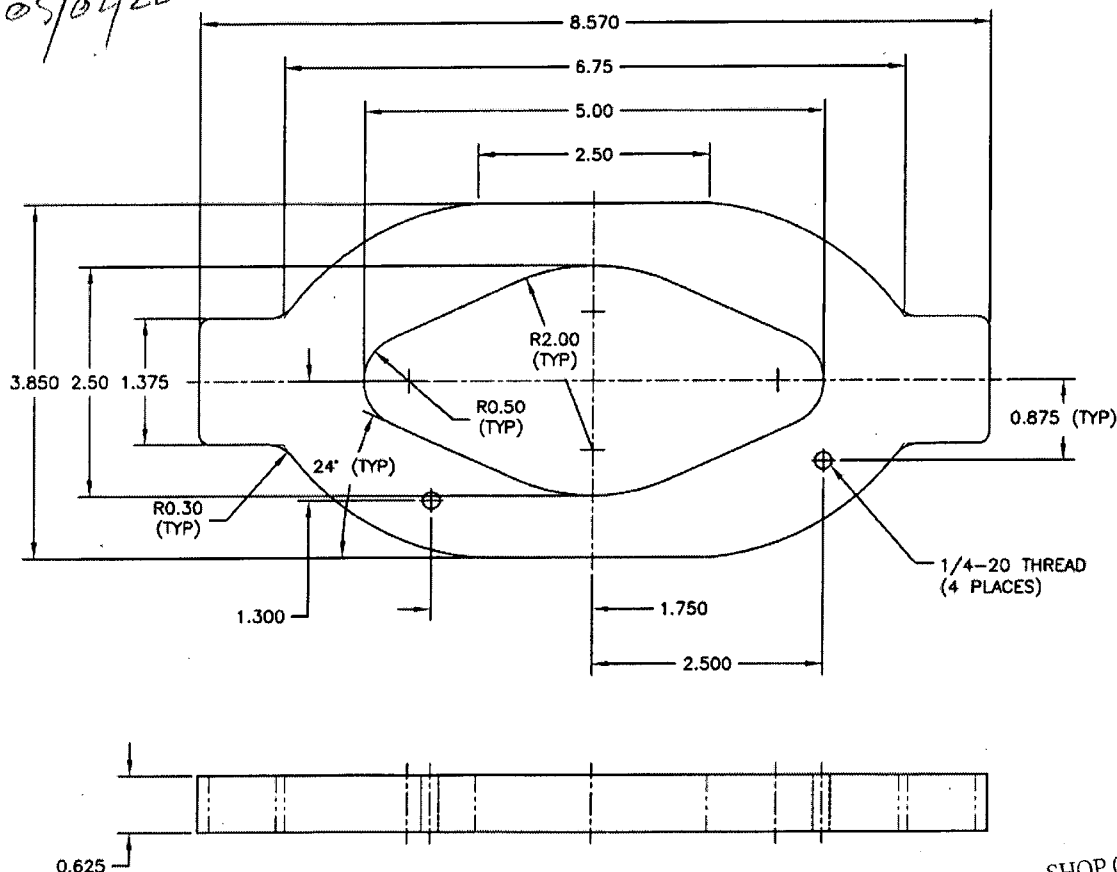
Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	07.03.21	Dimensions added	KJ/JLM	



DESIGN 7#	DRAWN BY 7#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED  
[Signature]

05/02/22



### D3333-1 BASE PLATE PANEL





#### NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B)  
MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE  
WORK ORDER  
NO. 37084

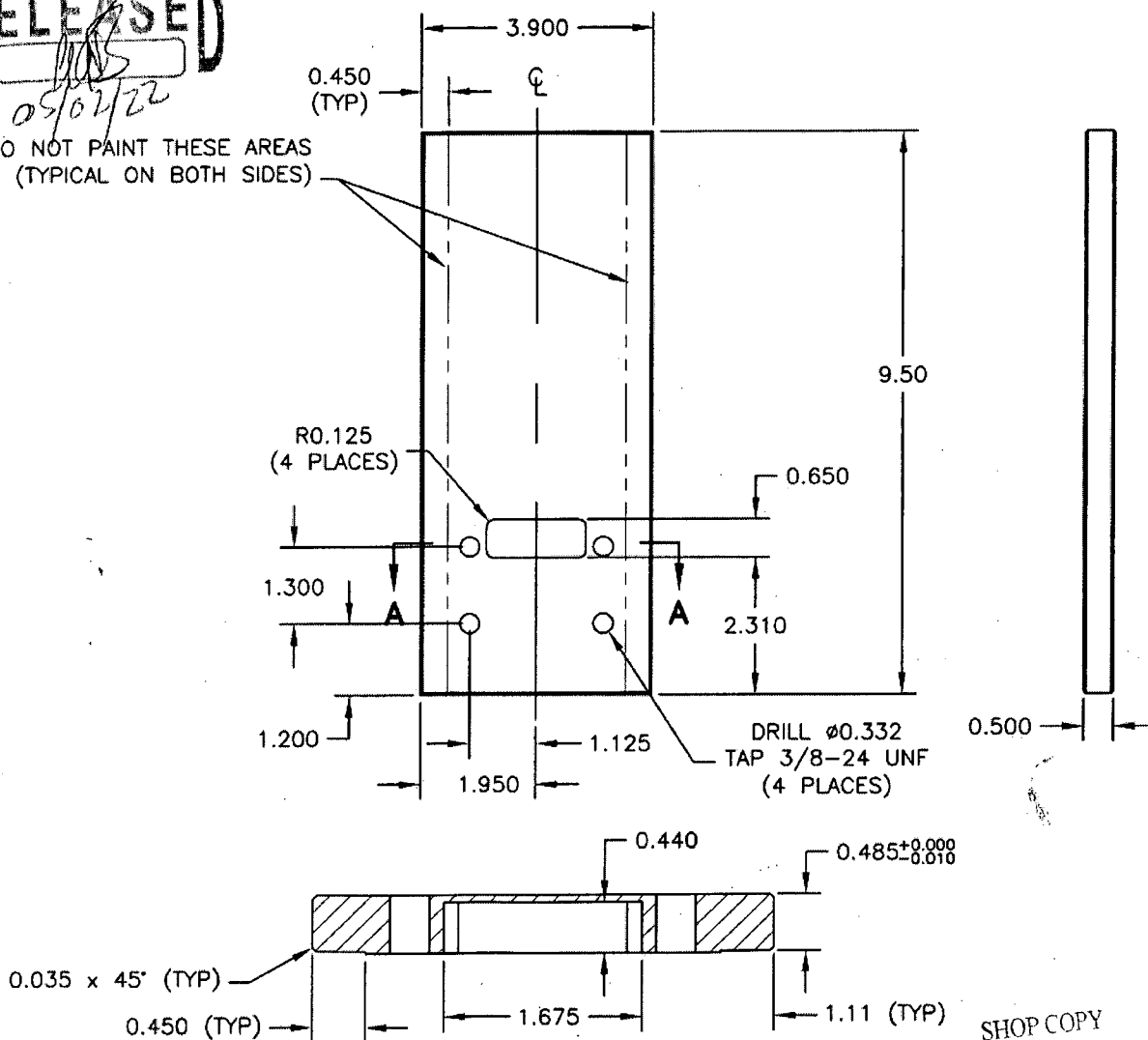
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DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3333	REV. B SHEET 2 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:4

RELEASED

DO NOT PAINT THESE AREAS  
(TYPICAL ON BOTH SIDES)



SECTION A-A

**D3333-3 SLIDING PLATE**

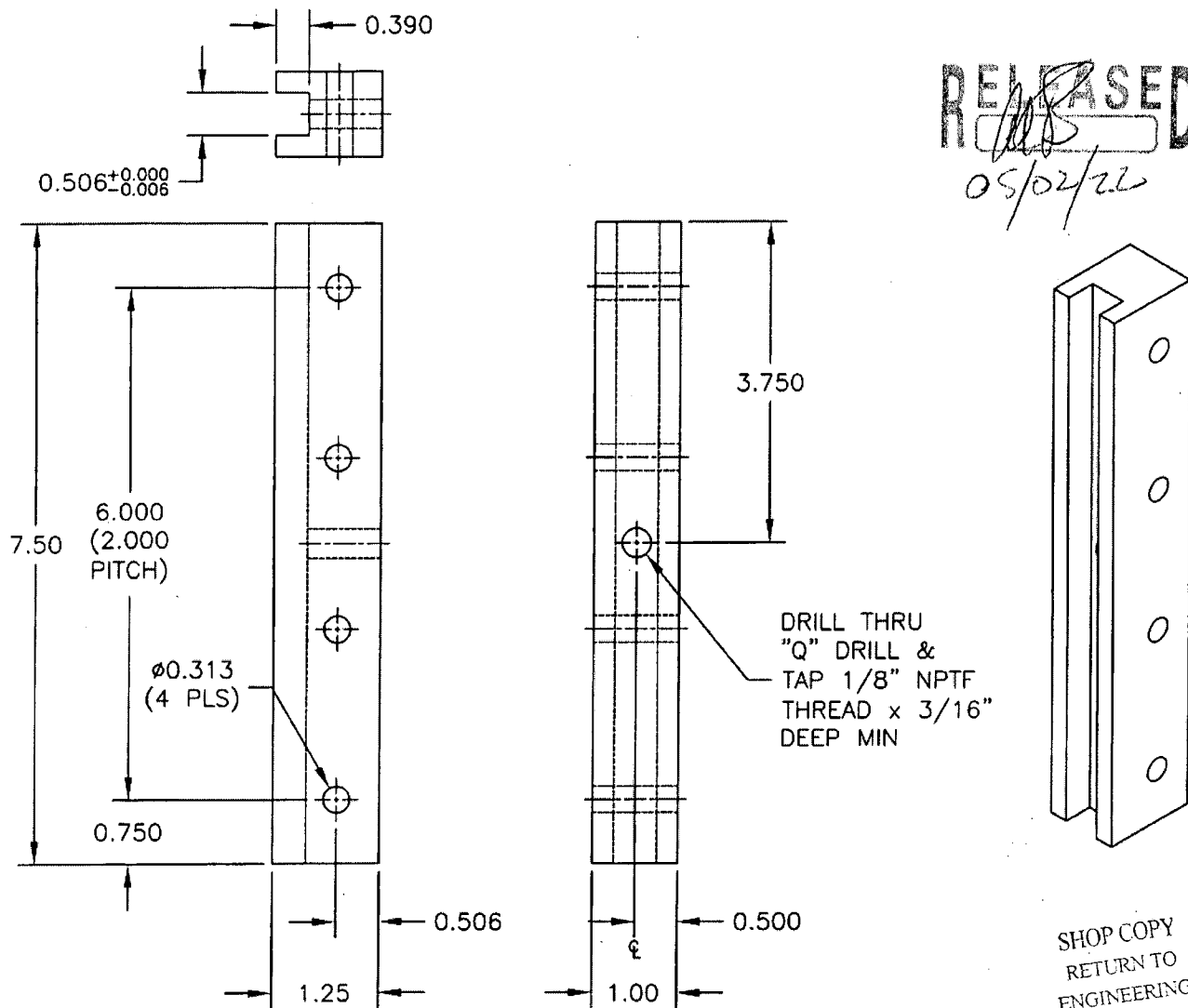
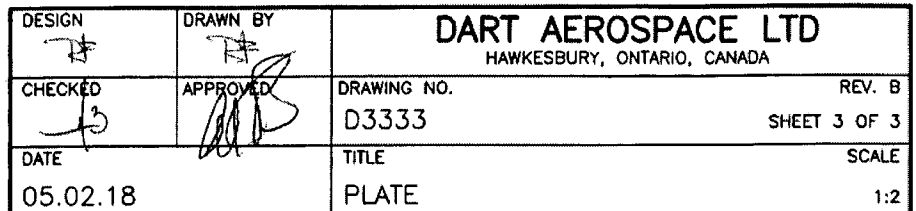
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK  
MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK STEEL  
(REF. DART SPEC. M1010-B)

2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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